



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9988

Form No. CNC/QA/FM/02

Rev. No. 01

Rev. Date 31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14860	28/38/60
3	Pallet Die No.		V.T.L. n/c Shop	Dr. H. 18.0.609
4	Die Category	Drg. No.	15017 (G.O) n/c	Rev. 03
5	Out Side Diameter	Drg. No.	M. 7000	
6	Inside Diameter	Drg. No.	680.7 n/c	Step 05 = 693 n/c
7	Width of Pellet Die	Drg. No.	546.12 n/c (Rev. 548.4 n/c)	Step 1 length 31 n/c
8	Grooves as per Drawing	Drg. No.	195 n/c	Under cut 2.5 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 + 9.2 n/c / 32.7 + 9.2 n/c	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		n/c Shop	2 n/c Deep
12	Tapping PCD		619 n/c	Both Side
13	Tapping Hole Diameter		N16	Tapping Hole
14	Tapping On Second Side	Half pitch of 1st side	Check by N16 Bolt	of Hole 2
15	Tapping Hole Depth		ok	Bolt Side
16	Perpendicularity of Tapped Hole		Drill Depth 33.4 n/c	Tapping Depth 31 n/c
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 17/5/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok							Counter 30
2	External Relief Dia	6.5 n/c / 1.0 n/c	6.5 n/c	All Rows 28 n/c					Row 12
3	External Relief Depth		1.0 n/c	All Rows 28 n/c					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Purvace					
6	Material Sent For Hardening On Date			17	5	25			

Inspected By (Sign) & Date

Ravi 17/5/25

Reviewed by (Engineer-CNC)

Manager-QA